

Split
Work Order ID 154400-2

Monday, December 12, 2016 4:24:21 PM

154400

Page 1

Item ID: D4004-041

Accept

Revision ID:

N900040100

Setup Start *NS1*

Item Name: Side Restraint Angle

Stop *NS2*

Start Date: 12/19/2016 Start Qty: ~~3.00~~ 1

3

Required Date: 1/3/2017 Req'd Qty: 3.00

3

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan: VS

Date: 16/12/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4004

B

100

0.02

100

Waterjet

Memo

0.05

FLOW CNC Waterjet

1-Cut as per Dwg (D4004-1)

Dwg Rev: 13

Prog Rev: R

2-Deburr if necessary

(3) 12/17/2016

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

(3) 12/17/2016

Work Order ID 154400

Monday, December 12, 2016 4:24:21 PM

154400

Page 2

Item ID: D4004-041

Revision ID:

Item Name: Side Restraint Angle

Start Date: 12/19/2016 Start Qty: 3.00

Required Date: 1/3/2017 Req'd Qty: 3.00

Reference:

Accept

N9000040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				3			DAS 38 9-88 IAN 20 2017
130 *130* Brake NC Brake NC	Bend as per dwg Memo 1- Bend D4004-1 as per Dwg 2- C'sink as per dwg	0.00 0.03				3X			DAS 30 9-88 17/02/14 DAS 36 9-88
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				3			DAS 38 9-88 FEB 15 2017

Monday, December 12, 2016 4:24:21 PM

Page 3

NS1

Stop *NS2*

3

3

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

NR1

Stop

NR2

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00

0.04

Stamp
20/02/22
BEB

0.00

0.01

3 of 17-03-23 DAS 34 9-89

0.00

0.04

N 22878. START: 2:30 3 0 17-03-23 DAS 34 9.89

Start Time: 3:00
Oven Temperature: 300°
Finish Time: 4:05

OD.T: 220°
FINISH: 3:00

1 ϕ 17-04-26. DAS 34 9-89

Work Order ID 154400

Monday, December 12, 2016 4:24:21 PM

154400

Page 4

Item ID: D4004-041

Revision ID:

Item Name: Side Restraint Angle

Start Date: 12/19/2016 Start Qty: 3.00

Required Date: 1/3/2017 Req'd Qty: 3.00

Reference:

Accept

N9000040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				3			DAS 38 9-89 MAR 24 2017
180 *180* Small Fab Small Fab	Memo Assemble as per dwg	0.00 0.14				1X			PTD next page 17/04/12 DAS 36 9-89
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				1			DAS 38 9-89 APR 27 2017



QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: <u>154400</u> Part No. <u>D4004-04</u> NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS				
	Rework ☒	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date: <u>17-03-27</u>	Step #: <u>130</u>	QTY Effective: <u>①</u>	MRB (QSI042) Approval <u>PD</u> <u>17-03-27</u>
-----------------------	--------------------	-------------------------	---

Description Work Order Deviation	Disposition	
When bucking rivet gun strip away + mark parts	removed D4004-3 + buff marks + strip + repaint parts - reclothe part	Completed By <u>PD</u> <u>17-03-28</u>
Add chlorine seq. (work order update) PD. per dng D4004		Lead hand / Supervisor Approval Verification DAS 30 9-89 <u>17-03-28</u>
		QC / QA Coordinator Approval DAS 9 9-89 <u>17-03-29</u>

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☒	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☒	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER: _____			

Work Order ID 154400

Monday, December 12, 2016 4:24:21 PM

154400

Page 5

Item ID: D4004-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Restraint Angle

Start Date: 12/19/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/3/2017 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>St24</u>	0.00							
200									
Packaging	Memo	0.01				1	DAS 6		
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.05							
Quality Control									17/5/11 

DAS
21
9-89

MAY 01 2017

Picklist Print

Monday, December 12, 2016 4:24:26 PM

Page 1

Work Order ID: 154400

Parent Item: D4004-041

Parent Item Name: Side Restraint Angle

154400

D4004-041

Start Date: 12/19/2016

Start Qty: 3.00

Required Date: 1/3/2017

Required Qty: 3.00

Comments: IPP rev A 09.12.15 new issue Prelim EC verified by:DD IPP Rev:B
10.05.17 as per ECN10-562 DD verf: IPP Rev:C 12.03.07 as
per dwg rev.b DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	40.0000	0.22	0.694737			

M2024T3S 063

2024-T3 .063 sheet

**

12/17/16

Location	Loc Qty	Loc Code
MAT	11.3	
m135512	11.3	
MAT009	28.7	
m135612	28.7	

D4004-3

D4004-3

Strut Lock Bracket

Manufactured No

180 Each 15.0000 1 3

**

17/03/27 DAS 36 9-89

Location	Loc Qty	Loc Code
GA	15	
106515	4	
113720	1	
126323	10	

D4004-7

D4004-7

Hose Clip

Manufactured No

180 Each 40.0000 1 3

**

17/03/27 DAS 36 9-89

Location	Loc Qty	Loc Code
GA	36	
122491	36	
ST070	4	
122491	4	

Picklist Print

Monday, December 12, 2016 4:24:26 PM

Work Order ID: 154400

154400

Parent Item: D4004-041

D4004-041

Parent Item Name: Side Restraint Angle

Start Date: 12/19/2016

Required Date: 1/3/2017

Start Qty: 3.00

Required Qty: 3.00

MS20426AD4-4

Purchased

No

180

Each

3,598.000

1

MS20426AD4-4

Rivet

17/03/27 ^{DAS} 36
9-89

Location

Loc Qty

Loc Code

GA

1641

125445

1641

ST312

1957

m132536

1957

MS20426AD4-5

Purchased

No

180

Each

1,198.000

2

MS20426AD4-5

RIVET

Location

Loc Qty

Loc Code

GA

800

m133751

800

DAS

ST312

398

36

9-89

m133751

398

DART AEROSPACE LTD		Work Order:	154400
Description: Side Restraint		Part Number:	D4004-1
Inspection Dwg: D4004 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

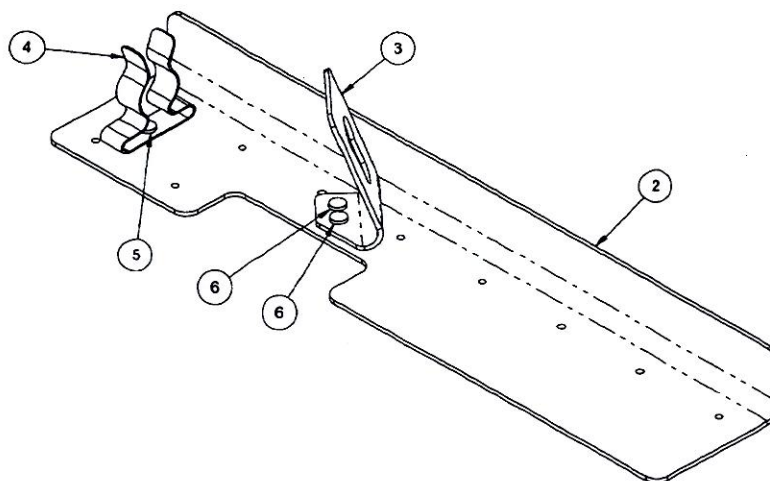
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø.097	/		Viper-02	
Ø0.129	+0.005/-0.001	Ø.128	/			
3.65	+/-0.030	3.65	/			
0.223	+/-0.010	.223	/			
10.63	+/-0.030	10.635	/			
2.99	+/-0.030	2.999	/			
5.79	+/-0.030	5.789	/			
0.87	+/-0.030	.866	/			
2.40	+/-0.030	2.40	/			
1.38	+/-0.030	1.377	/			
0.50	+/-0.030	.502	/			
0.79	+/-0.030	.788	/			
0.38	+/-0.030	.377	/			
0.98	+/-0.030	.986	/			
1.18	+/-0.030	1.18	/			
1.56	+/-0.030	1.566	/			
0.063	+/-0.010	.062	/			

Measured by:	DC	Audited by:	DAS 38	Preliminary Approval:	
Date:	17/01/20	Date:	9-8P	Date:	

IAN 20 2017

Rev	Date	Change	Revised by	Approved
A	10.08.03	New Issue P/O D4004-041	KJ	
B	13.02.27	Dwg Rev updated	KJ	

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-041	SIDE RESTRAINT ANGLE	JCA-M47-2-19
2	1	D4004-1	SIDE RESTRAINT	
3	1	D4004-3	ANGLE	
4	1	D4004-7	HOSE CLIP	
5	1	MS20426AD4-4	RVET	
6	2	MS20426AD4-5	RVET	



D4004-041 SIDE RESTRAINT ANGLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154403

JAN 20 2017

RELEASED
2012-03-03

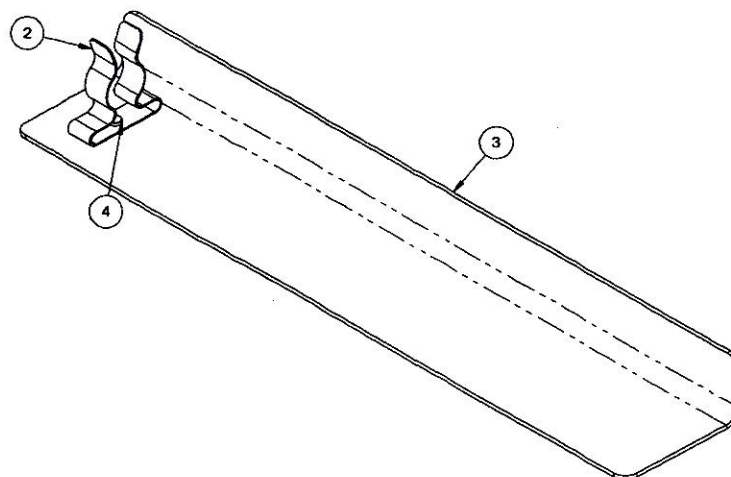
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs



B	CHANGE POWDER COAT FROM "GREY SANDTEX" TO "ANSI 61 GREY", ZN A8-1, ZN A8-2.	DC	12.02.27
A	NEW ISSUE	HS	10.02.10
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DC</i>		
CHECKED	<i>DC</i>	DRAWING NO.	REV.
MFG. APPR.	<i>DC</i>	D4004	SHEET 1 OF
APPROVED	<i>DC</i>	TITLE	SCALE
DE APPR.	<i>DC</i>	SIDE RESTRAINT	NT
DATE	12.02.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-043	SIDE RESTRAINT ANGLE AND TIE DOWN POINT	JCA-M47-2-04
2	1	D4004-7	HOSE CLIP	
3	1	D4004-9	ANGLE	
4	1	MS20426AD4	RIVET	



D4004-043 SIDE RESTRAINT ANGLE AND TIE DOWN POINT

RELEASED
2012-03-02
M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.20 lbs

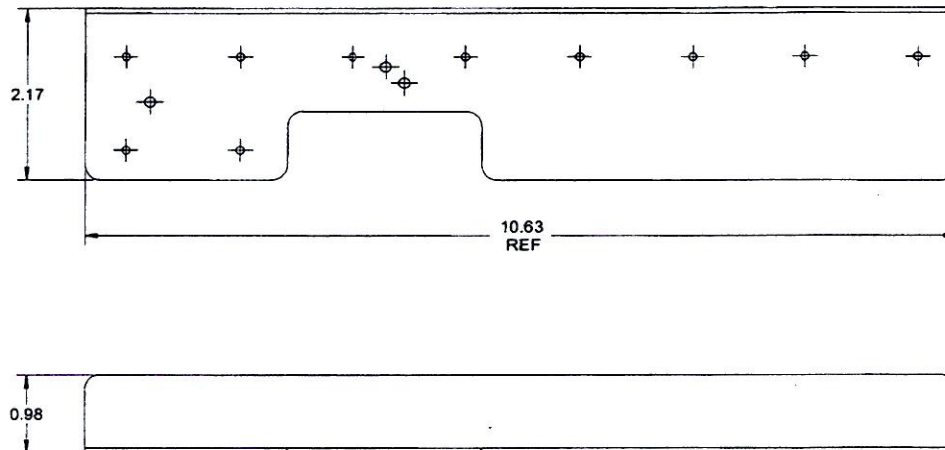
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4004	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE
PART NUMBER

D4004-1

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-19



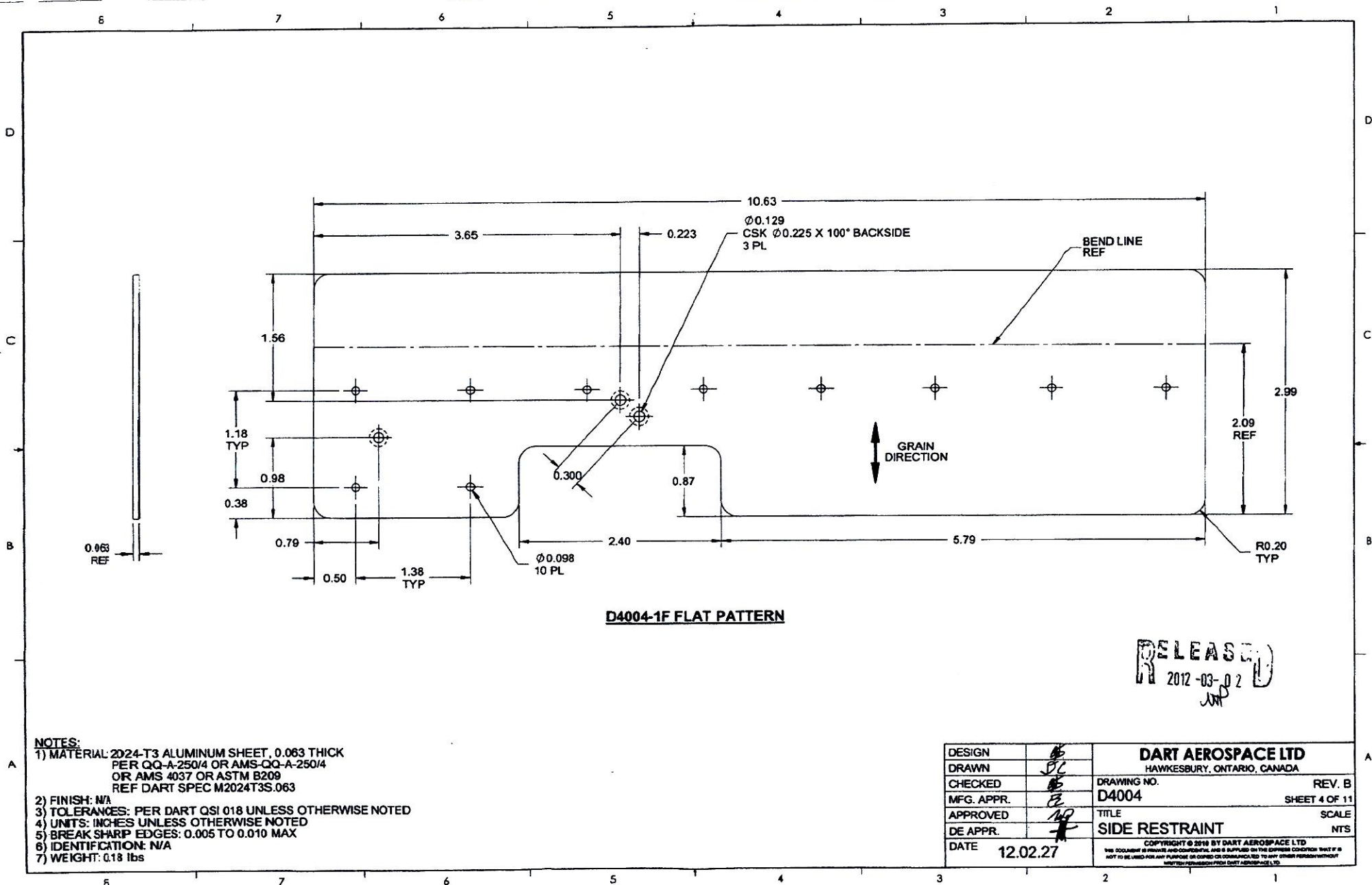
D4004-1 SIDE RESTRAINT

NOTES:

- 1) MATERIAL: MADE FROM D4004-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

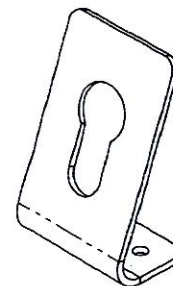
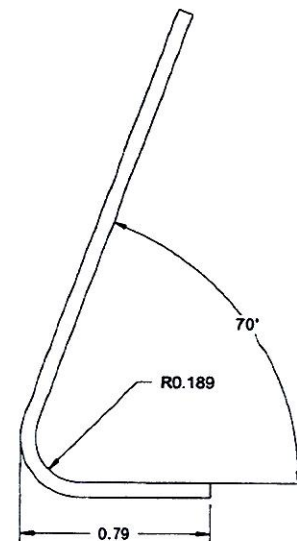
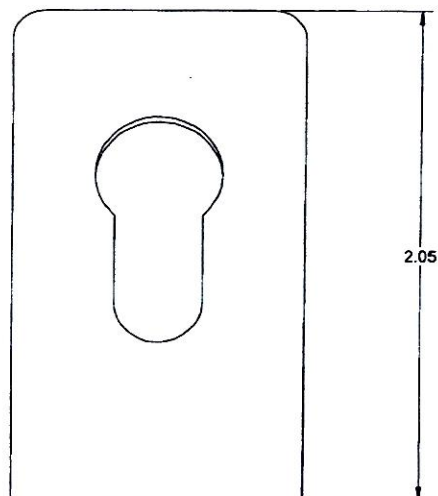
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4004	SHEET 3 OF 11
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2012-03-02
MD



DART AEROSPACE
PART NUMBER
D4004-3

JOHN CAMERON AVIATION
PART NUMBER
REF JCA-M47-2-19



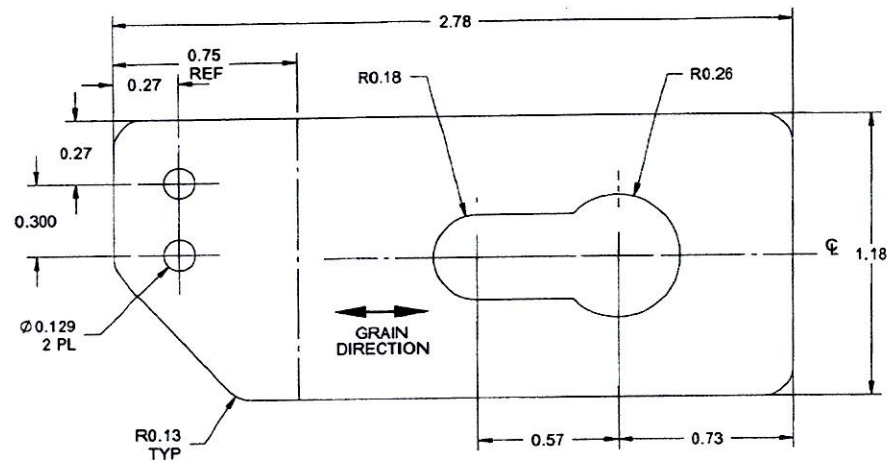
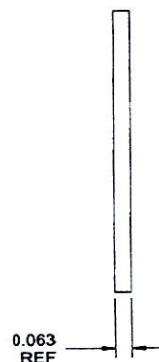
D4004-3 STRUT LOCK BRACKET

RELEASED
2012-03-02
MP

NOTES:

- 1) MATERIAL: MADE FROM D4004-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	BE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BE		
CHECKED	BE	DRAWING NO. D4004	REV. B
MFG. APPR.	BE	SHEET 5 OF 11	
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED AND CONTAINS NO OTHER INFORMATION THAT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4004-3F FLAT PATTERN

RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

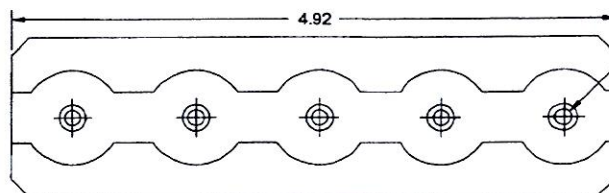
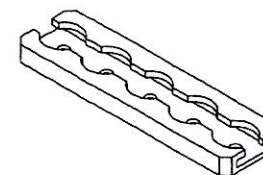
DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4004	SHEET 6 OF 11
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE
PART NUMBER

D4004-5

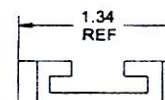
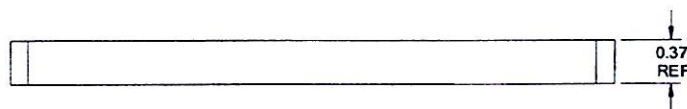
JOHN CAMERON AVIATION
PART NUMBER

JCA-M47-2-23



DRILL $\varnothing 0.129$ (#30 DRILL)
CONCENTRIC WITH SEAT TRACK
CSK $\varnothing 0.225 \times 100^\circ$
5 PL

CHAMFER 0.15 X 45°
TYP



D4004-5 BOTTOM STRAP ATTACH BRACKET

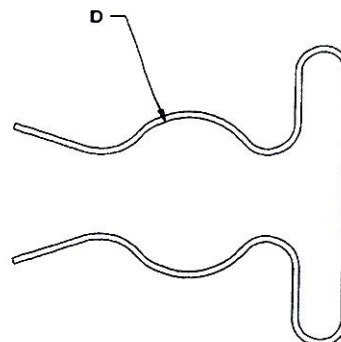
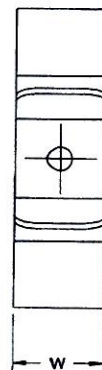
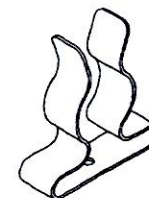
RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: MADE FROM ANCR P/N 40456-11-144
OR BROWNLINE P/N 20276-144-0-0
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.14 lbs

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4004	SHEET 7 OF 11
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SPECIFICATION CONTROL DRAWING



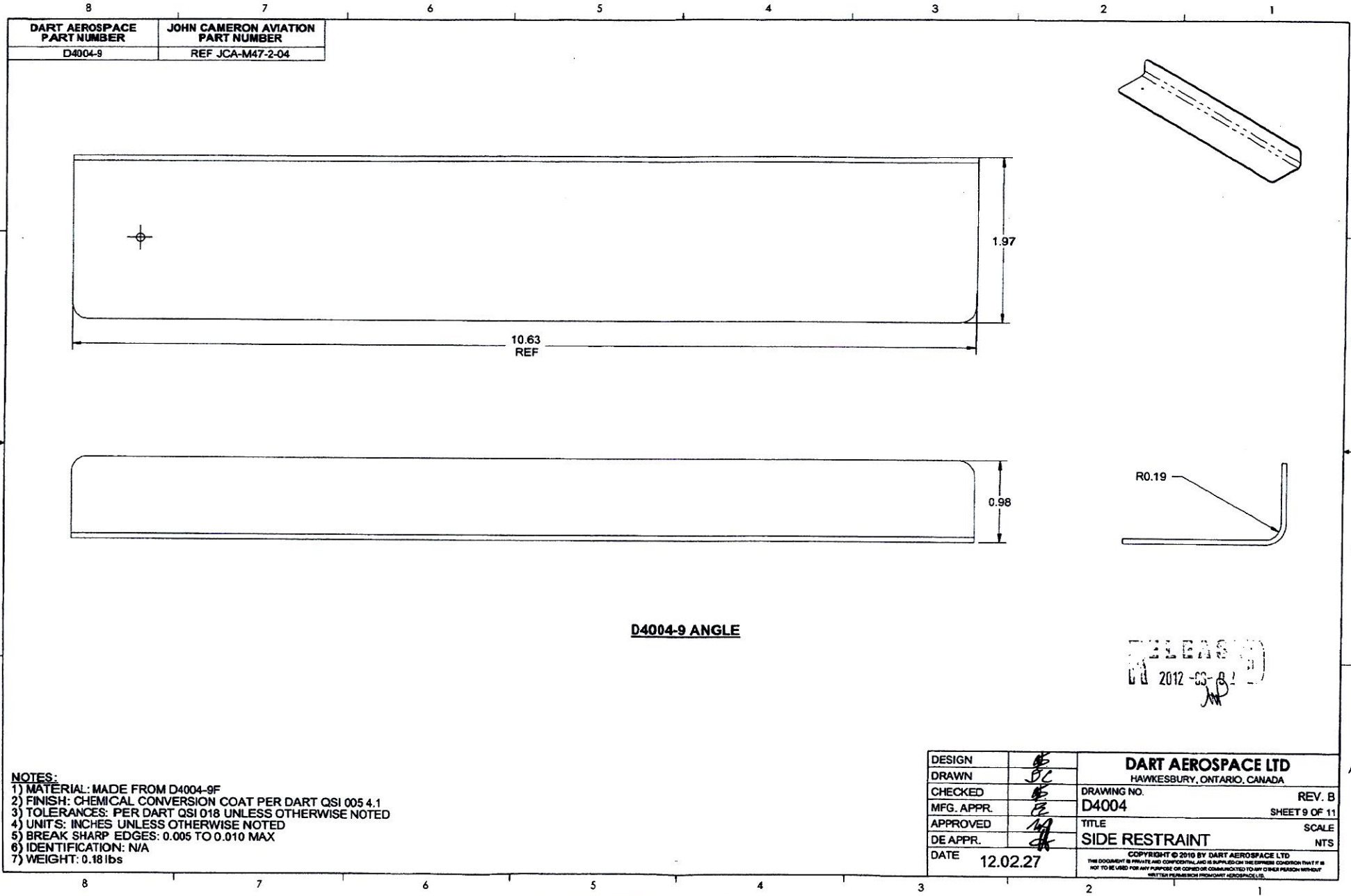
DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	FITS TUBE Ø "D"	WIDTH "W"
D4004-7	MCMASTER-CARR	1722A42	NICKEL PLATED STEEL	0.31 - 0.75	0.38

D4004-X HOSE CLIP

RELEASED
11 2012-03-02

- NOTES:
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.01 lbs

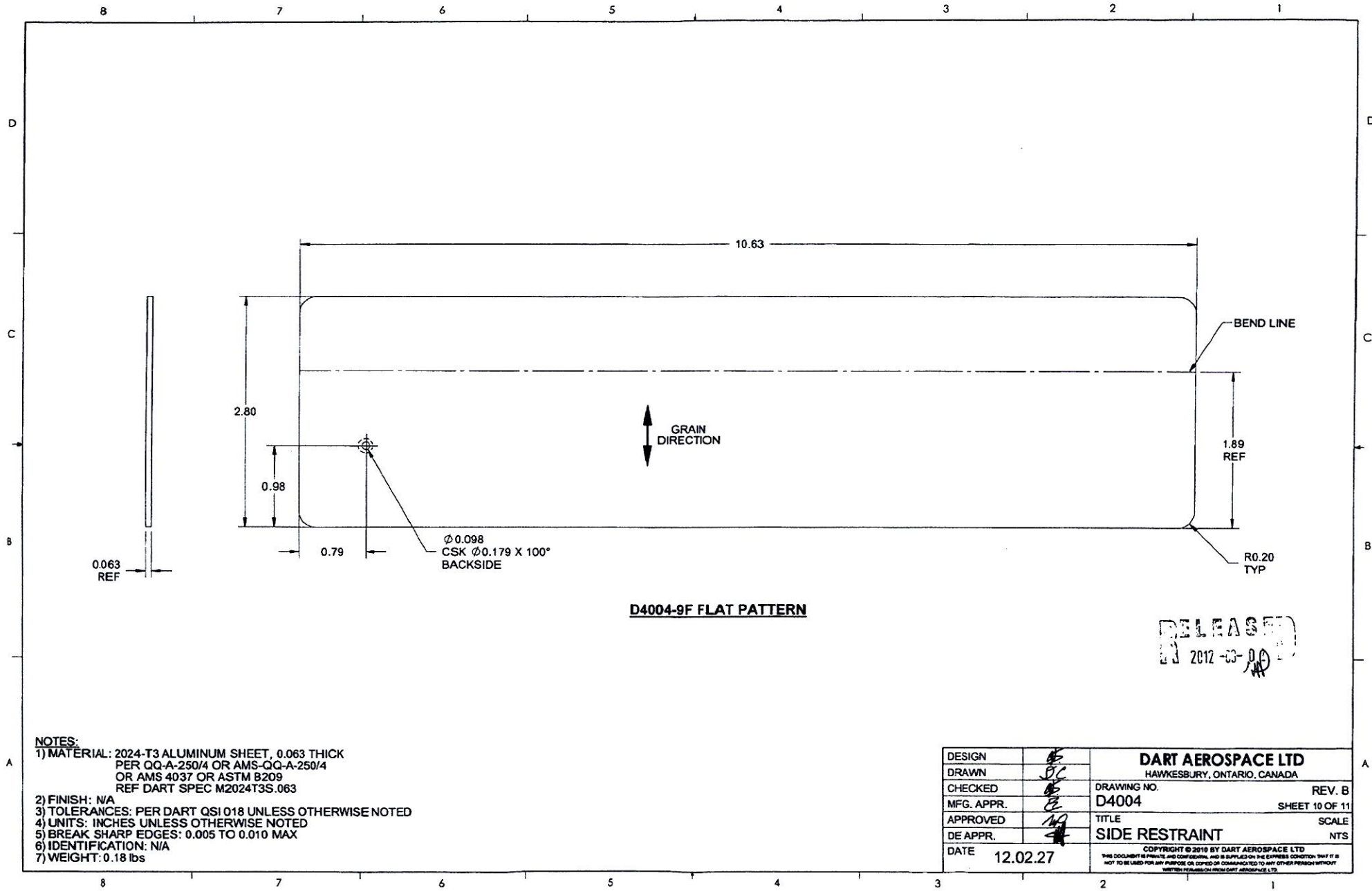
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4004	SHEET 8 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4004-9 ANGLE

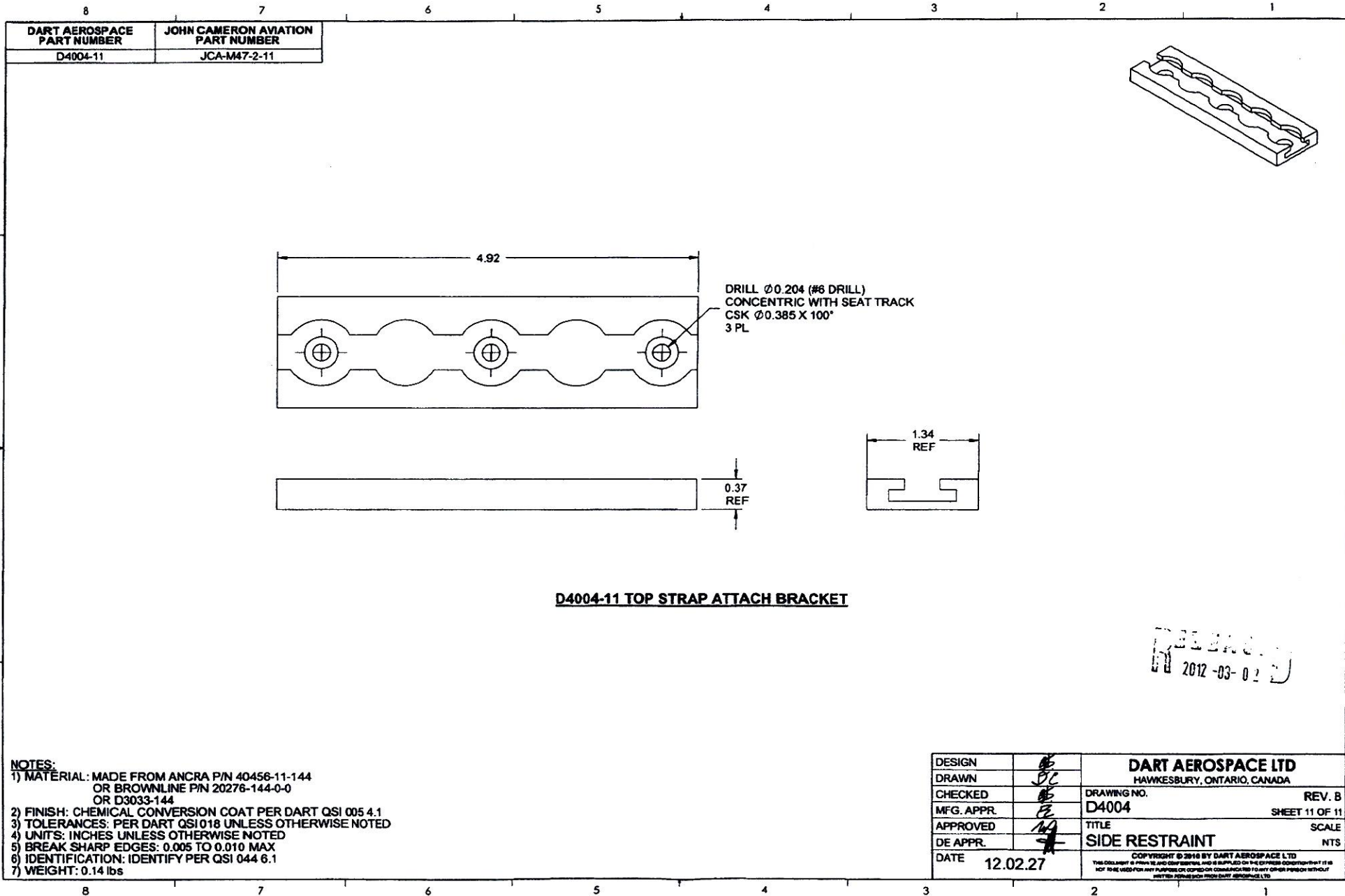
- NOTES:**
- 1) MATERIAL: MADE FROM D4004-9F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.18 lbs

DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	FE	D4004	SHEET 9 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.18 lbs

DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DL		
CHECKED	AS	DRAWING NO. D4004	REV. B
MFG. APPR.	BE	SHEET 10 OF 11	
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
OR BROWNLIN P/N 20276-144-0-0
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.14 lbs

DESIGN	<i>DC</i>	DART AEROSPACE LTD	
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DC</i>	D4004	SHEET 11 OF 11
APPROVED	<i>DC</i>	TITLE	SCALE
DE APPR.	<i>DC</i>	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			